

**THERMALLY HARDENABLE EPOXY RESIN COMPOSITION HAVING AN IMPROVED IMPACT RESISTANCE AT LOW TEMPERATURES****Field of the invention**

5

The invention relates to thermally hardenable compositions which simultaneously have a high impact resistance and good mechanical properties at low temperatures down to -40°C and in particular can be 10 used as one-component adhesives, and impact modifiers for epoxy resins at low temperatures.

**Description of the prior art**

15 In the manufacture both of vehicles and add-on parts and of machines and devices, high-quality adhesives are being used with increasing frequency instead of or in combination with conventional joining methods, such as screwing, riveting, punching or welding. This gives 20 rise to advantages and new possibilities in manufacture, for example for the manufacture of composite and hybrid materials, or greater latitudes in the design of components. For an application in vehicle production, the adhesives must have good adhesion to 25 all substrates used, in particular electrolytically galvanized, hot-galvanized and subsequently phosphated steel sheets, oiled steel sheets and various, optionally surface-treated, aluminum alloys. These good adhesion properties must in particular also be retained 30 after aging (climatic cycling, salt spray bath, etc.) without major deteriorations in quality. If the adhesives are used as body-shell adhesives in automotive construction, the resistance of these adhesives to cleaning baths and dip coating (so-called 35 wash-out resistance) is of major importance for enabling the manufacturer's process reliability to be guaranteed.

- The adhesives for body-shell construction must harden under the customary baking conditions of, ideally, 30 min at 180°C. However, they must furthermore also be  
5 resistant up to about 220°C. Further requirements for such a hardened adhesive or of the adhesive bond are the guarantee of operational safety both at high temperatures up to about 90°C and at low temperatures down to about -40°C. Since these adhesives are  
10 structural adhesives, and these adhesives therefore adhesively bond structural parts, high strength and impact resistance of the adhesive are of very great importance.
- 15 It is true that conventional epoxy adhesives are distinguished by high mechanical strength, in particular high tensile strength. When the adhesive bond is subjected to stress by impact, however, classical epoxy adhesives are generally too brittle and  
20 therefore are far from able to meet the requirements, in particular in the automotive industry, under crash conditions under which both great tensile stresses and cleavage stresses occur. In particular, the strengths at high temperatures but in particular at low  
25 temperatures (< -10°C) are often insufficient in this context.

The literature proposes substantially two methods for enabling the brittleness of epoxy adhesives to be  
30 reduced and hence the impact resistance to be increased: firstly, the aim can be achieved by the admixing of at least partly crosslinked high molecular weight compounds, such as latices of core/shell polymers or other flexibilizing polymers and  
35 copolymers. Secondly, a certain increase in toughness can also be achieved by introducing flexible segments, for example by the corresponding modification of the epoxide components.

- 3 -

According to the first-mentioned technique corresponding to the teaching in the US Patent 5,290,857, epoxy resins can be made more impact resistant by mixing a fine, pulverulent core/shell polymer into the epoxide matrix. This gives rise to highly resilient domains in the rigid brittle epoxide matrix which increase the impact strength. Such core/shell polymers are described in US Patent 5,290,857 and are based on acrylate or methacrylate polymers.

According to the second-mentioned technique, US Patent 4,952,645 describes epoxy resin compositions which were flexibilized by the reaction with aliphatic, cycloaliphatic or aromatic carboxylic acids, in particular di- or trimeric fatty acids, and with carboxylic acid-terminated aliphatic or cycloaliphatic diols. Such compositions should be distinguished by increased flexibility, in particular at low temperatures.

EP 0 343 676 describes a reactive hotmelt epoxy adhesive comprising a polyurethane-epoxide adduct. The terminal isocyanate groups of prepolymers are reacted with at least one epoxy resin containing hydroxyl groups and having an OH functionality greater than 2, so that a hotmelt adhesive solid at room temperature is obtained.

It is also known that epoxy resins can be flexibilized with elastomers, such as synthetic rubbers and derivatives thereof. The main effect in relation to the imparting of tough and resilient properties is based on the only partial miscibility of the epoxy resins and the corresponding derivatized synthetic rubbers, with the result that heterodisperse phases which have an effect comparable to the core/shell polymers form in the production process. However, the establishment of

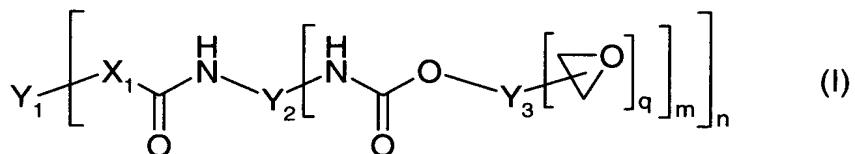
- 4 -

this superstructure is very dependent both on the quantitative composition and on the procedure during the hardening process. The result of this is that a continuously constant quality is very difficult to achieve.

#### **Summary of the invention**

It is the object of the present invention to provide novel impact modifiers for epoxy resin compositions, which impact modifiers are suitable in particular for use at low temperatures. These impact modifiers should preferably be suitable as a component of one-component and thermally hardening compositions which are stable at room temperature, in particular adhesives and hotmelt adhesives.

Surprisingly, it was found that this can be achieved by using polymeric compounds terminated with epoxide groups and of the general formula (I) :



in which  $X_1$  is O, S or NH;

$Y_1$  is an n-valent radical of a reactive polymer after removal of the terminal amino, thiol or hydroxyl groups;

$Y_2$  is a divalent radical of aliphatic, cycloaliphatic, aromatic or araliphatic diisocyanates after removal of the isocyanate groups

or is a trivalent radical of trimers or biurets of aliphatic, cycloaliphatic, aromatic or araliphatic

- 5 -

diisocyanates after removal of the isocyanate groups;

Y<sub>3</sub> is a radical of an aliphatic, cycloaliphatic, aromatic or araliphatic epoxide containing a primary or  
5 secondary hydroxyl group after removal of the hydroxide and epoxide groups;  
and q is 1, 2 or 3; m is 1 or 2 and n is 2, 3 or 4.

It has been found that this polymer of the formula (I)  
10 is a good impact modifier.

A particular aspect of the invention relates to a composition which comprises at least one epoxide adduct  
A having on average more than one epoxide group per molecule and at least one polymer B of the formula (I)  
15 and at least one thixotropic agent C, based on a urea derivative in a non-diffusing carrier material, and at least one hardening agent D for epoxy resins, which is activated by elevated temperature. This composition serves in particular as an adhesive and has an extremely high dynamic resistance to cleavage, in  
20 particular at low temperatures.

According to preferred embodiments, compositions which additionally contain at least one filler E and/or at  
25 least one reactive diluent F are furthermore described.

The invention furthermore relates to impact modifiers terminated with epoxide groups and of the formula (I). It has been found that these novel impact modifiers result in a significant increase in impact resistance in epoxy resin compositions, in particular 1-component thermally hardening epoxy resin compositions and in 2-component epoxy resin compositions.  
30

### 35 **Description of the preferred embodiments**

The present invention relates to compositions which contain at least one epoxide adduct A having on average

- 6 -

more than one epoxide group per molecule, at least one polymer **B** of the formula (I), at least one thixotropic agent **C**, based on a urea derivative in a non-diffusing carrier material, and at least one hardening agent **D** for epoxy resins, which is activated by elevated temperature.

The epoxide adduct **A** is an epoxide adduct **A1** or an epoxide adduct **A2**.

10

The epoxide adduct **A1** is obtainable from the reaction of at least one dicarboxylic acid and at least one diglycidyl ether. The epoxide adduct **A2** is obtainable from the reaction of at least one bis(aminophenyl) sulfone isomer or of at least one aromatic alcohol and at least one diglycidyl ether.

20 The dicarboxylic acid used for the preparation of the epoxide adduct **A1** is preferably a dimeric fatty acid. Dimeric C<sub>4</sub>-C<sub>20</sub> fatty acids which are C<sub>8</sub>-C<sub>40</sub> dicarboxylic acids have proven to be particularly suitable.

25 The diglycidyl ethers are preferably a liquid resin, in particular the diglycidyl ether of bisphenol A (DGEBA), of bisphenol F and of bisphenol A/F (the designation "A/F" refers here to a mixture of acetone with formaldehyde, which is used as a starting material in the preparation thereof). Owing to the processes for the preparation of these resins, it is clear that the 30 liquid resins also contain higher molecular weight components. Such liquid resins are obtainable, for example, as Araldite GY 250, Araldite PY 304, Araldit GY 282 (Vantico) or D.E.R 331 (Dow).

35 The epoxide adduct **A1** has a flexibilizing character.

The epoxide adduct **A2** is obtainable by the reaction of at least one bis(aminophenyl) sulfone isomer or at

- 7 -

- least one aromatic alcohol with at least one diglycidyl ether. The aromatic alcohol is preferably selected from the group consisting of 2,2-bis(4-hydroxyphenyl)propane (= bisphenol A), bis(4-hydroxyphenyl)methane (= bisphenol F), bis(4-hydroxyphenyl) sulfone, hydroquinone, resorcinol, pyrocatechol, naphthoquinone, naphthoresorcinol, dihydroxynaphthalene, dihydroxy-anthraquinone, dihydroxybiphenyl, 3,3-bis(p-hydroxyphenyl)phthalides, 5,5-bis(4-hydroxyphenyl)-hexahydro-4,7-methanoindane and all isomers of the abovementioned compounds. Bis(4-hydroxyphenyl) sulfone is suitable as a particularly preferred aromatic alcohol.
- 15 The preferred bis(aminophenyl) sulfone isomers are bis(4,-aminophenyl) sulfone and bis(3-aminophenyl) sulfone.
- 20 The preferred diglycidyl ethers are the diglycidyl ethers already described for epoxide adduct **A1**.

The epoxide adduct **A2** tends to have a rigid structure.

- 25 The simultaneous presence of epoxide adduct **A1** and epoxide adduct **A2** in compositions as claimed in claim 1 is particularly preferred.

30 The epoxide adduct **A** preferably has a molecular weight of 700 - 6000 g/mol, preferably 900 - 4000 g/mol, in particular 1000 - 3300 g/mol. Here and below, "molecular weight" is understood as meaning the average molecular weight  $M_n$ .

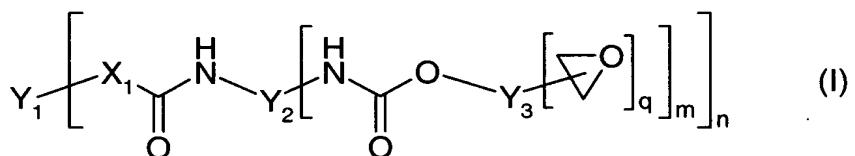
- 35 The preparation of the epoxide adduct **A** is effected in the manner known to the person skilled in the art. Advantageously, an additional amount of the diglycidyl ether or diglycidyl ethers used for adduct formation is added at the end of the adduct formation and used as

- 8 -

epoxide adduct **A** pre mix. In this epoxide adduct **A** pre mix, the total proportion of the unreacted diglycidyl ether or diglycidyl ethers is 12 - 50% by weight, preferably 17 - 45% by weight, based on the 5 total weight of the epoxide adduct **A** pre mix.

Here and below, "total proportion" is understood in each case as meaning the sum of all components belonging to this category. If, for example, two 10 different diglycidyl ethers occur simultaneously in the adduct formation, the total proportion of the diglycidyl ether is to be understood as meaning the sum of these two diglycidyl ethers.

- 15 Furthermore, the proportion by weight of the epoxide adduct **A** pre mix is advantageously 20 - 70% by weight, preferably 35 - 65% by weight, based on the weight of the total composition.
- 20 The polymer **B** can be represented by the formula (I)



Here,  $X_1$  is O, S or NH.  $Y_1$  is an n-valent radical of a reactive polymer after removal of the terminal amino, thiol or hydroxyl groups.  $Y_2$  is a divalent radical of aliphatic, cycloaliphatic, aromatic or araliphatic diisocyanates after removal of the isocyanate groups or is a trivalent radical of trimers or biurets of aliphatic, cycloaliphatic, aromatic or araliphatic diisocyanates after removal of the isocyanate groups.  $Y_3$  25 is a radical of an aliphatic, cycloaliphatic, aromatic or araliphatic epoxide containing a primary or secondary hydroxyl group after removal of the hydroxide and epoxide groups.

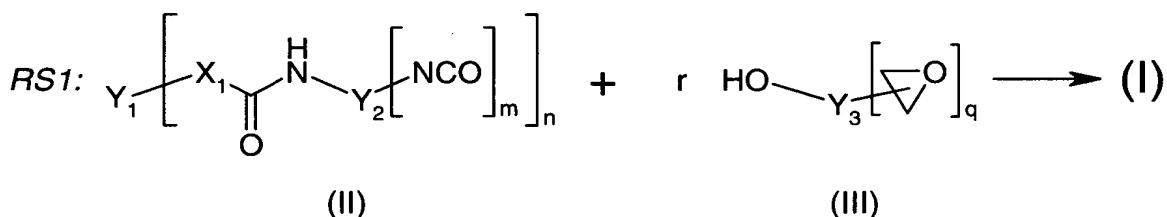
- 9 -

The values  $q = 1, 2$  or  $3$  apply to the indices  $q$ , and the values  $m = 1$  or  $2$  apply to  $m$ , while the values  $n = 2, 3$  or  $4$  apply to  $n$ .

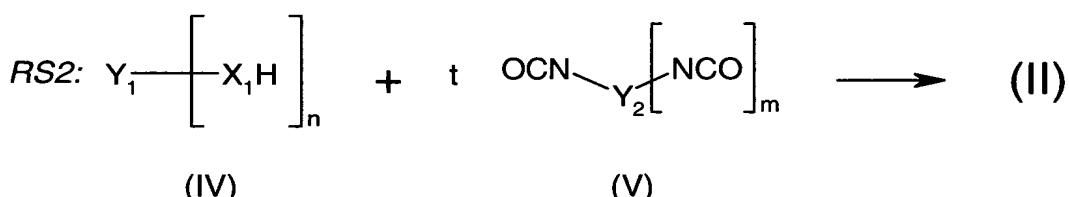
5

The polymer **B** of the formula (I) is obtainable, for example, by reacting isocyanate-terminated prepolymers of the formula (II) with monohydroxy-epoxide compounds of the formula (III) according to the reaction RS1:

10



The isocyanate-terminated prepolymers of the formula (II) which are used are the reaction product of polyisocyanates of the formula (V) and compounds of the formula (IV) which carry  $X_1H$  groups according to the reaction *RS2*:



The polymers of the formula (IV) have groups  $X_1H$ . These may be, independently of one another, OH, SH or NH<sub>2</sub>. The hydroxyl group is preferred.

Preferred compounds of the formula (IV) are polyols, for example the following commercially available polyols or any desired mixtures thereof:

- polyoxyalkylenepolyols, also referred to as polyetherpolyols, which are the polymerization product

- 10 -

of ethylene oxide, 1,2-propylene oxide, 1,2- or 2,3-butylene oxide, tetrahydrofuran or mixtures thereof, optionally polymerized with the aid of an initiator molecule having two or three active H atoms, such as, 5 for example, water or compounds having two or three OH groups. Both polyoxyalkylenepolyols which have a low degree of unsaturation (measured according to ASTM D-2849-69 and stated in milliequivalent of unsaturation per gram of polyol (meq/g)), prepared, for 10 example, with the aid of so-called double metal cyanide complex catalysts (DMC catalysts for short) and polyoxyalkylenepolyols having a higher degree of unsaturation, prepared, for example, with the aid of anionic catalysts, such as NaOH, KOH or alkali metal 15 alcoholates, may be used. Polyoxypropylenediols and -triols having a degree of unsaturation of less than 0.02 meq/g and having a molecular weight in the range of 1000 - 30 000 g/mol, polyoxybutylenediols and -triols, polyoxypropylenediols and -triols having a molecular weight of 400 - 8000 g/mol and so-called "EO-endcapped" (ethylene oxide-endcapped) polyoxypropylenediols or -triols are especially suitable. The latter are special polyoxypropylenepolyoxyethylenepolyols 20 which are obtained, for example, by alkoxylation pure polyoxypropylenepolyols with ethylene oxide after the end of the polypropoxylation and thus have primary 25 hydroxyl groups;

- polyhydroxyl-terminated polybutadienepolyols;
- polyesterpolyols prepared, for example, from 30 dihydric or trihydric alcohols, such as, for example, 1,2-ethanediol, diethylene glycol, 1,2-propanediol, dipropylene glycol, 1,4-butanediol, 1,5-pentanediol, 1,6-hexanediol, neopentylglycol, glycerol, 1,1,1-trimethylolpropane or mixtures of the abovementioned 35 alcohols with organic dicarboxylic acids or anhydrides or esters thereof, such as, for example, succinic acid, glutaric acid, adipic acid, suberic acid, sebacic acid, dodecanedicarboxylic acid, maleic acid, fumaric acid,

- 11 -

phthalic acid, isophthalic acid, terephthalic acid and hexahydrophthalic acid or mixtures of the abovementioned acids, and polyesterpolyols obtained from lactones, such as, for example,  $\epsilon$ -caprolactone;

5           - polycarbonatepolyols as obtainable by reaction of, for example, the abovementioned alcohols - used for the synthesis of the polyesterpolyols - with dialkyl carbonates, diaryl carbonates or phosgene.

10          The polymers of the formula (IV) are advantageously difunctional or higher functional polyols having OH equivalent weights of from 600 to 6000 g/OH equivalent, preferably from 700 to 2200 g/OH equivalent. The polyols are furthermore advantageously selected from  
15         the group consisting of polyethylene glycols, polypropylene glycols, polyethylene glycol/polypropylene glycol block polymers, polybutylene glycols, hydroxyl-terminated polybutadiene, hydroxyl-terminated polybutadiene-co-acrylonitrile, hydroxyl-  
20         terminated synthetic rubbers and mixtures of these stated polyols.

Furthermore, with difunctional or higher functional amine-terminated polyethylene ethers, polypropylene ethers, polybutylene ethers, polybutadienes, polybutadiene/ acrylonitriles and further amine-terminated synthetic rubbers or mixtures of said components may also be used as polymers of the formula (IV).

30           $\alpha, \omega$ -Polyalkylene glycol having C<sub>2</sub>-C<sub>6</sub>-alkylene groups or having mixed C<sub>2</sub>-C<sub>6</sub>-alkylene groups, which are terminated with amino, thiol or, preferably, hydroxyl groups, are particularly preferred as polymers of the formula (IV).  
35          Polyoxybutylenes terminated with hydroxyl groups are particularly preferred.

The polyisocyanates of the formula (V) are

- 12 -

diisocyanates or triisocyanates. Suitable diisocyanates are aliphatic, cycloaliphatic, aromatic or araliphatic diisocyanates, in particular commercially available products, such as methylenediphenyl diisocyanate (MDI),  
5 hexamethylene diisocyanate (HDI), toluene diisocyanate (TDI), tolidene diisocyanate (TODI), isophorone diisocyanate (IBDI), trimethylhexamethylene diisocyanate (TMDI), 2,5- or 2,6-bis(isocyanatomethyl)-bicyclo[2.2.1]heptane, 1,5-naphthalene diisocyanate  
10 (NDI), dicyclohexylmethyl diisocyanate ( $H_{12}$ MDI), p-phenylene diisocyanate (PPDI), m-tetramethylxylylene diisocyanate (TMXDI), etc., and the dimers thereof. HDI, IPDI, MDI or TDI are preferred.

Suitable triisocyanates are trimers or biurets of aliphatic, cycloaliphatic, aromatic or araliphatic diisocyanates, in particular the isocyanurates and biurets of the diisocyanates described in the preceding paragraph.

20 A further possibility for  $Y_1$  comprises chain-extended radicals of molecules after removal of the  $X_1H$  groups, which are formally obtainable by a reaction similar to equation RS2 between the di- and triols and/or di- or triamines already mentioned above and the di- or  
25 triisocyanates already mentioned. By varying t equation RS2, or the stoichiometry, there are two possibilities for this.

Firstly, OH-functional polymers having chains of  
30 different lengths can be obtained by means of an excess of the  $X_1H$  groups, based on the NCO groups. Such chain-extended polyols or polyamines of the formula (IV) contain urethane or urea groups in the chain and can be further reacted with other di- or triisocyanates so  
35 that polymers of the formula (II) form.

Secondly, NCO-functional polymers of the formula (II) having chains of different lengths can be obtained by

- 13 -

means of an excess of the  $X_1H$  groups, based on the NCO groups.

5 The chain length and degree of crosslinking of these chain-extended polymers of the formula (II) are very dependent on the ratio  $[X_1H]/[NCO]$ . The chains are the longer the more closely this ratio approaches 1. It is clear to the person skilled in the art that chains which are too long or a degree of crosslinking which is 10 too high would lead to polymers which are no longer usable.

Diols or diamines and diisocyanates are particularly preferred for the chain extension.

15 The monohydroxy-epoxide compound of the formula (II) has 1, 2 or 3 epoxide groups. The hydroxide group of this monohydroxy-epoxide compound (II) may be a primary or a secondary hydroxyl group.

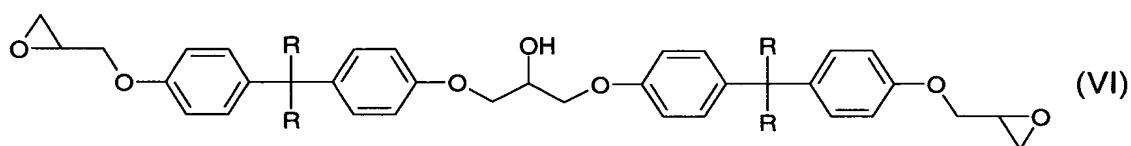
20 Corresponding amounts of monohydroxyl-containing epoxides of the formula (III) can be used for the reaction of the terminal isocyanates thus obtained. However, it is possible to depart from the stoichiometry which is given in equation RS1 by 25  $r = m \cdot n$ , corresponding to a ratio  $[\text{OH}]/[\text{NCO}] = 1$ . The ratio  $[\text{OH}]/[\text{NCO}]$  is from 0.6 to 3.0, preferably from 0.9 to 1.5, in particular from 0.98 to 1.1.

30 Depending on the reaction procedure, the corresponding monohydroxy-epoxide compounds are also formed as byproducts in different concentrations in the reaction of polyfunctional alcohols with epichlorohydrin. Said monohydroxy-epoxide compounds can be isolated by customary separation operations. As a rule, however, it 35 is sufficient to use the product mixture obtained in the glycidylation reaction of polyols and comprising polyol completely and partly reacted to give the glycidyl ether. Examples of such hydroxyl-containing

- 14 -

epoxides are trimethylolpropanediglycidyl ether (contained as a mixture in trimethylolpropane-triglycidyl ether), glyceryldiglycidyl ether (contained as a mixture in glyceryltriglycidyl ether),  
 5 pentaerythrityltriglycidyl ether (contained as a mixture in pentaerythrityltetraglycidyl ether). Trimethylolpropanediglycidyl ether, which occurs in relatively high proportions in customarily prepared trimethylolpropanetriglycidyl ether, is preferably  
 10 used.

However, it is also possible to use other similar hydroxyl-containing epoxides, in particular glycitol, 3-glycidyloxybenzyl alcohol or hydroxymethylcyclohexene oxide. The  $\beta$ -hydroxyether of the formula (VI), which is contained in an amount of about 15% in commercially available liquid epoxy resins prepared from bisphenol A (R = CH<sub>3</sub>) and epichlorohydrin, and the corresponding  $\beta$ -hydroxyethers which are formed in the reaction of bisphenol F (R = H) or of the mixture of bisphenol A and bisphenol F with epichlorohydrin, are furthermore preferred.  
 15  
 20



25 Furthermore, very different epoxides having a  $\beta$ -hydroxyether group, prepared by the reaction of (poly)epoxides with less than the stoichiometric amount of a monofunctional nucleophile, such as carboxylic acids, phenols, thiols or sec-amines, can also be used.  
 30

The free primary or secondary OH functionality of the monohydroxy-epoxide compound of the formula (III) permits an efficient reaction with terminal isocyanate groups of prepolymers without disproportionate excess

- 15 -

amounts of the epoxide components having to be used for this purpose.

5 The polymer **B** advantageously has a resilient character and is furthermore advantageously soluble or dispersible in epoxy resins.

10 The polymer **B** can, if required and depending on the resulting viscosity, be diluted with further epoxy resins. Diglycidyl ethers of bisphenol A, bisphenol F and bisphenol A/F, but also the reactive diluents **F** described further below and containing epoxide groups, in particular hexanediol glycidyl ether, polypropylene glycol diglycidyl ether and trimethylolpropane 15 triglycidyl ether, are preferred for this purpose.

The total proportion of the polymer **B** is advantageously 5 - 40% by weight, preferably 7 - 30% by weight, based on the weight of the total composition.

20 The composition furthermore contains at least one thixotropic agent **C** based on a urea derivative in a non-diffusing carrier material. The preparation of such urea derivatives and carrier materials are described in detail in the Patent Application EP 1 152 019 A1. The carrier material is advantageously a block polyurethane prepolymer **C1**, in particular obtained by reaction of a trifunctional polyetherpolyol with IPDI and subsequent blocking of the terminal isocyanate groups with caprolactam.

25 The urea derivative is a reaction product of an aromatic monomeric diisocyanate with an aliphatic amine compound. It is also entirely possible to react a plurality of different monomeric diisocyanates with one or more aliphatic amine compounds or a monomeric diisocyanate with a plurality of aliphatic amine compounds. The reaction product of 4,4'-diphenylmethylenediiisocyanate (MDI) with butylamine 35

- 16 -

has proven to be particularly advantageous.

The total proportion of the thixotropic agent **C** is advantageously 5 - 40% by weight, preferably 10 - 25% by weight, based on the weight of the total composition. The proportion of the urea derivative is advantageously 5 - 50% by weight, preferably 15 - 30% by weight, based on the weight of the thixotropic agent **C**.

The composition according to the invention furthermore contains at least one hardening agent **D** for epoxy resins, which is activated by elevated temperature. This is preferably a hardening agent which is selected from the group consisting of dicyandiamide, guanamines, guanidines, aminoguanidines and derivatives thereof. Catalytically active substituted ureas, such as 3-chloro-4-methylphenylurea (chlortoluron) or phenylmethylureas, in particular p-chlorophenyl-N,N-dimethylurea (monuron), 3-phenyl-1,1-dimethylurea (fenuron) or 3,4-dichlorophenyl-N,N-dimethylurea (diuron), are furthermore possible. Compounds of the class consisting of the imidazoles and amine complexes may furthermore be used. Dicyandiamide is particularly preferred.

The total proportion of the hardening agent **D** is advantageously 1 - 10% by weight, preferably 2 - 8% by weight, based on the weight of the total composition.

In a preferred embodiment, the composition additionally contains at least one filler **E**. This is preferably mica, talc, kaolin, wollastonite, feldspar, chlorite, bentonite, montmorillonite, calcium carbonate (precipitated or ground), dolomite, quartz, silicas (pyrogenic or precipitated), cristobalite, calcium oxide, aluminum hydroxide, magnesium oxide, hollow ceramic balls, hollow glass balls, hollow organic

- 17 -

balls, glass balls or colored pigments. Both the organically coated and the uncoated commercially available forms known to the person skilled in the art are meant by filler **E**.

5

The total proportion of the total filler **E** is advantageously 5 - 30% by weight, preferably 10 - 20% by weight, based on the weight of the total composition.

10

In a further preferred embodiment, the composition additionally contains at least one reactive diluent **F** carrying epoxide groups. These reactive diluents **F** are in particular:

15

- glycidyl ethers of monofunctional saturated or unsaturated, branched or straight-chain, cyclic or open-chain C<sub>4</sub>-C<sub>30</sub> alcohols, e.g. butanol glycidyl ether, hexanol glycidyl ether, 2-ethylhexanol ether, allyl glycidyl ether, tetrahydrofurfuryl and furfuryl glycidyl ether, trimethoxysilyl glycidyl ether, etc.

20

- glycidyl ethers of difunctional saturated or unsaturated, branched or straight-chain, cyclic or open-chain C<sub>2</sub>-C<sub>30</sub> alcohols, e.g. ethylene glycol glycidyl ether, butanediol glycidyl ether, hexanediol glycidyl ether, octanediol glycidyl ether, cyclohexanedimethanol diglycidyl ether, neopentylglycol diglycidyl ether, etc.

25

- glycidyl ethers of tri- or polyfunctional, saturated or unsaturated, branched or straight-chain, cyclic or open-chain alcohols, such as epoxidized castor oil, epoxidized trimethylolpropane, epoxidized pentaerythritol or polyglycidyl ether of aliphatic polyols, such as sorbitol, glycerol, trimethylolpropane, etc.

30

- glycidyl ethers of phenol and aniline compounds, such as phenyl glycidyl ether, cresol glycidyl ether, p-tert-butylphenyl glycidyl ether, nonylphenol glycidyl ether, 3-n-pentadecenyl glycidyl

35

- 18 -

ether (from cashew nut shell oil), N,N-diglycidylaniline, etc.

- epoxidized tertiary amines, such as N,N-diglycidylcyclohexylamine, etc.

5 - epoxidized mono- or dicarboxylic acids, such as glycidyl neodecanoate, glycidyl methacrylate, glycidyl benzoate, diglycidyl phthalate, tetrahydrophthalate and hexahydrophthalate, diglycidyl esters of dimeric fatty acids, etc.

10 - epoxidized di- or trifunctional, low molecular weight to high molecular weight polyetherpolyols, such as polyethylene glycol diglycidyl ether, polypropylene glycol diglycidyl ether, etc.

15 Hexanediol diglycidyl ether, polypropylene glycol diglycidyl ether and polyethylene glycol diglycidyl ether are particularly preferred.

20 The total proportion of the reactive diluent **F** carrying epoxide groups is advantageously 1 - 7% by weight, preferably 2 - 6% by weight, based on the weight of the total composition.

25 It has been found that the composition according to the invention are at least successfully suitable as one-component adhesives. In particular, thermally hardening one-component adhesives which are distinguished by a high impact resistance both at relatively high temperatures and especially at low temperatures, in particular from 0°C to -40°C, can be realized therewith. Such adhesives are required for the adhesive bonding of heat-stable materials. Heat-stable materials are understood as meaning materials which are dimensionally stable at a hardening temperature of 100  
30 - 220°C, preferably 120 - 200°C, at least during the hardening time. These are in particular metals and plastics, such as ABS, polyamide, polyphenylene ether, composite materials, such as SMC, unsaturated polyester  
35

- 19 -

glass fiber-reinforced plastics, composite epoxide or acrylate materials. The use in which at least one material is a metal is preferred. The adhesive bonding of identical or different metals, in particular in body-shell construction in the automotive industry, is considered to be a particularly preferred use. The preferred metals are especially steel, in particular electrolytically galvanized, hot-galvanized, oiled steel, bonazinc-coated steel, and subsequently phosphated steel, and aluminum, in particular in the variants typically occurring in automotive construction.

In particular, the desired combination of high crash strength and high and low temperature of use can be achieved with an adhesive based on a composition according to the invention.

Such an adhesive is first brought into contact at a temperature of 10°C to 80°C, in particular from 10°C to 60°C, with the materials to be adhesively bonded and then hardened, typically at a temperature of 100 - 220°C, preferably 120 - 200°C.

Of course, in addition to thermally hardening adhesives, sealing compounds or coatings can also be realized with a composition according to the invention. Furthermore, the compositions according to the invention are suitable not only for automotive construction but also for other fields of use. Particularly obvious are related applications in construction of means of transport, such as ships, trucks, buses or railway vehicles, or in the construction of consumer goods, such as, for example, washing machines.

The materials adhesively bonded by means of a composition according to the invention are used at

- 20 -

temperatures of, typically, from 100°C to -40°C, preferably from 80°C to -40°C, in particular from 50°C to -40°C.

5 The compositions typically have a fracture energy, measured according to DIN 11343, of more than 10 J at 0°C, and preferably more than 1.0 J at -40°C. Fracture energies of more than 11.5 J at 0°C and of more than 1.5 J at -40°C are particularly preferred.

10 Hotmelt adhesives based on the composition according to the invention can also be realized in a special manner. Here, the hydroxyl groups forming in the case of the epoxide adduct **A** are additionally reacted with 15 polyisocyanate or a polyisocyanate prepolymer. The viscosity is increased thereby, and hot application is required.

20 A further aspect of the invention relates to novel impact modifiers of the formula (I) which are terminated with epoxide groups and whose detailed constitution and methods of preparation have already been described further above.

25 It has been found that these impact modifiers of the formula (I) which are terminated with epoxide groups can be added to compositions containing epoxy resin. In addition to the thermally curing 1-component compositions already described, they are also very 30 suitable in the case of 2-component or multicomponent epoxy resin compositions, in particular for those whose second component is an amine hardening agent or a polyamine hardening agent. The impact modifiers of the formula (I) which are terminated with epoxide groups 35 are added to the hardening component, one or more adducts being formed, or preferably are added to that component which contains the epoxy resin. Further, less preferred possibilities are the addition of an impact

- 21 -

modifier terminated with epoxide groups directly during the application or the addition as constituent of a third or further component during the application.

5 The hardening temperature of such 2-component or multicomponent epoxy resin compositions is preferably from 10°C to 60°C, in particular from 15°C to 50°C. Impact modifiers of the formula (I) which are terminated with epoxide groups are particularly 10 suitable as an additive to 2-component epoxy resin adhesives. Here, the increase in the impact resistance is not limited to low temperatures.

15 These compositions, in particular adhesives, are applied immediately before application by means of a 2-component or multicomponent mixing apparatus to the materials to be brought into contact. Such 2-component or multicomponent adhesives can be used both in 20 automotive construction and in the construction of means of transport (ships, trucks, buses or railway vehicles) or in the construction of consumer goods, such as, for example, washing machines, but also in the building sector, for example as stiffening structural adhesives (inter alia composite materials, etc.).

25

### **Examples**

Some examples which further illustrate the invention but are not intended to limit the scope of the 30 invention in any way are to be described below. The raw materials used in the examples are listed in table 1.

General preparation of the epoxide adduct **A** of the epoxide adduct **A** premix:

35

#### Example for epoxide adduct **A** premix: **A-VM1**

123.9 g of a dimeric fatty acid, 1.1 g of triphenylphosphine and 71.3 g of bis(4-hydroxyphenyl)

- 22 -

sulfone were reacted with 658 g of a liquid DGEBA epoxy resin having an epoxide content of 5.45 eq/kg for 5 hours at 110°C in vacuo and with stirring until a constant epoxide concentration of 2.82 eq/kg had been 5 reached. After the end of the reaction, 187.0 g of liquid DGEBA epoxy resin were additionally added to the reaction mixture **A**.

<b>Raw materials used</b>	<b>Supplier</b>
Dimerized C18 fatty acid (Pripol 1013)	Uniquema
Triphenylphosphine	Fluka AG
Bis(4-hydroxyphenyl) sulfone	Fluka AG
Bisphenol A diglycidyl ether (= DGEBA)	Vantico
Polypropylene glycol diglycidyl ether (ED-506)	Asahi-Denka Kogyo
Dicyandiamide (= Dicy)	Degussa
Isophorone diisocyanate (= IPDI)	Degussa-Hüls
Caprolactam	EMS Chemie
N-Butylamine	BASF
4, 4'-Diphenylmethlene diisocyanate (= MDI)	Bayer
Hexanediol diglycidyl ether	Prümmer
Alcupol® D-2021 (difunctional polypropylene glycol, OH equivalent weight = 1000 g/OH equivalent)	Repsol
Desmophen 3060 BS (trifunctional polypropylene glycol, OH equivalent weight = 1000 g/OH equivalent)	Bayer
PolyTHF 1000 (difunctional polybutylene glycol, OH equivalent weight = 500 g/OH equivalent)	BASF
PolyTHF 2000 (difunctional polybutylene glycol, OH equivalent weight = 1000 g/OH equivalent)	BASF
Poly bd® R45 HT (hydroxyl-terminated polybutadiene, OH equivalent weight = about 1200 g/OH equivalent)	Atofina
Struktol Polydis® 3604 (nitrile rubber-modified epoxy resin (epoxide content 3.0 eq/kg)	Schill + Seilacher

**Table 1**

Exemplary preparation of a monohydroxyl-containing epoxide

Trimethylolpropane glycidyl ether was prepared according to the process in US Patent 5,668,227, example 1, from trimethylolpropane and epichlorohydrin with tetramethylammonium chloride and sodium hydroxide solution. A yellowish product having an epoxide number of 7.5 eq/kg and a hydroxyl group content of 1.8 eq/kg is obtained. From the HPLC-MS spectrum, it is possible to conclude that trimethylolpropane diglycidyl ether is and present in substantial proportions in trimethylolpropane triglycidyl ether.

Different examples of the preparation of the polymer **B** of the formula (I) are described below.

Example 1 of a polymer **B**: **B-01**

200 g of polyTHF 2000 (OH number 57.5 mg/g KOH) were dried for 30 minutes in vacuo at 100°C. 47.5 g of IPDI and 0.04 g of dibutyltin dilaurate were then added. The reaction was carried out in vacuo at 90°C to a constant NCO content of 3.6% after 2.5 h (theoretical NCO content: 3.7%). 123.7 g of the trimethylolpropane glycidyl ether described above were then added as monohydroxyl-containing epoxide of the formula (III). Stirring was continued at 90°C in vacuo until the NCO content had decreased below 0.1% after a further 3 h. After the end of the reaction, 82.5 g of DGEBA were added (1/3 of the mass of the unblocked prepolymer having terminal NCO). A clear product having epoxide content ("final EP content") of 3.15 eq/kg was obtained.

Examples 2-5 of a polymer **B**: **B-02** to **B-05**

The exemplary polymers **B** summarized in table 2 and terminated with epoxide groups, referred to as **B-02** to **B-05**, were synthesized on the basis of different polyols or polyol mixtures according to the table

- 25 -

below, in the same manner as described for example **B-01**. The amount of trimethylolpropane glycidyl ether required for terminating the terminal NCO groups was exactly adapted to the NCO content reached after the 5 first synthesis stage. The amount of DGEBA added for dilution was calculated in the case of all prepolymers as 1/3 of the mass of the prepolymer prepared in the first synthesis stage and having terminal NCO.

10 Example 6 of a chain-lengthened polymer **B**: **B-06**

Example 6 **B-06** is an example of a polymer **B** in which the Y<sub>1</sub>-based polymer is a chain-extended diol.

15 200 g of polyTHF 1000 (OH number 114 mg/g KOH) were dried for 30 minutes in vacuo at 100°C. 73.5 g of IPDI and 0.04 g of dibutyltin dilaurate were then added. This corresponds to a molar [NCO]/[OH] ratio of 1.6/1 and, as already described, leads to a chain extension of the polymer forming. The reaction was carried out in 20 vacuo at 90°C to a constant NCO content of 4.9% after 2.5 h (theoretical NCO content: 5.1%). 186.1 g of the trimethylolpropane glycidyl ether described above were added as monohydroxyl-containing epoxide of the formula (III). Stirring was continued at 90°C in vacuo until 25 the NCO content had decreased below 0.1% after a further 3.5 h. After the end of the reaction, 91.2 g of DGEBA were added (1/3 of the mass of the unblocked prepolymer having terminal NCO). Thus, a clear product having an epoxide content ("final EP content") of 30 3.50 eq/kg was obtained.

Example No.	Polyols used (formula (IV))	Hydroxyl number (mg/g KOH)	Final EP content (eq/kg)
<b>B-01</b>	PolyTHF 2000	57.5	3.15
<b>B-02</b>	Desmophen 3060 BS	55.5	3.10
<b>B-03</b>	Desmophen 3060 BS/ poly Bd® R45 HT (w/w ratio 8/2)	53.5	3.13
<b>B-04</b>	Alcupol® D-2021	56.0	3.15
<b>B-05</b>	PolyTHF 2000/ poly Bd® R45 HT (w/w ratio 8/2)	55.5	3.13
<b>B-06</b>	PolyTHF 1000	114	3.50

**Table 2**Thixotropic agent C

5 As an example of a thixotropic agent **C** based on a urea derivative in a non-diffusing carrier material, one according to Patent Application EP 1 152 019 A1 was prepared in a blocked polyurethane prepolymer using abovementioned raw materials:

10

*Carrier material: Blocked polyurethane prepolymer **C1**:*

15 600.0 g of a polyetherpolyol (3000 g/mol; OH number 57 mg/g KOH) were reacted in vacuo and with stirring at 90°C with 140.0 g of IPDI to give the isocyanate-terminated prepolymer until the isocyanate content remained constant. The free isocyanate groups were then blocked with caprolactam (2% excess).

*Urea derivative (**HSD1**) in blocked polyurethane prepolymer:*

20 68.7 g of MDI flakes in 181.3 g of the blocked prepolymer described above were melted under nitrogen and with gentle heating. 40.1 g of N-butylamine, dissolved in 219.9 g of the blocked prepolymer

- 27 -

described above were then added dropwise in the course of two hours under nitrogen and with rapid stirring. After the end of the addition of the amine solution, the white paste was stirred for a further 30 minutes. 5 Thus, a white, soft paste which had a free isocyanate content of < 0.1% was obtained after cooling (proportion of urea derivative about 20%).

Example compositions

10 Various adhesive compositions according to table 3 were prepared as examples.

The highly structural epoxide adhesive Betamate-1493 (commercially available from Dow-Automotive, 15 Freienbach, Switzerland), as examples **Ref-01** not according to the invention, and **Ref-02** to **Ref-04** were used as comparison reference to the example compositions according to the invention.

20 After application to electrolytically galvanized steel (eloZn), the adhesives were hardened at 50°C in the course of 30 minutes in an oven at 180°C. All tests were effected only after cooling of the adhesive to room temperature.

25

**Test methods:**

Tensile shear strength (TSS) (DIN EN 1465)

30 The test specimens were produced with electrolytically galvanized steel (eloZn) having the dimensions 100 x 25 x 0.8 mm; the adhesion area was 25 x 10 mm, with a layer thickness of 0.3 mm. Hardening was effected for 30 min at 180°C. The traction rate was 10 mm/min.

Dynamic resistance to cleavage (ISO 11343)

35 The test specimens were produced with electrolytically galvanized steel (eloZn) having the dimensions 90 x 25 x 0.8 mm; the adhesion area was 25 x 30 mm with a layer thickness of 0.3 mm. Hardening was effected for

- 28 -

30 min at 180°C. The traction rate was 2 m/s. The area under the curve (from 25% to 90%, according to DIN 11343) is stated as the fracture energy in Joules.

	<b>Ref-01</b>	<b>Ref-02</b>	<b>Ref-03</b>	<b>Ref-04</b>	<b>Z-01</b>	<b>Z-02</b>	<b>Z-03</b>	<b>Z-04</b>	<b>Z-05</b>	<b>Z-06</b>
<b>A-VM1 [g]</b>		55.6	55.6	55.6	55.6	55.6	55.6	55.6	55.6	55.6
Additive DGEBA [g]				3.3						
Polydis® 3604 [g]			18.0							
<b>B-01 [g]</b>					18.0					
<b>B-02 [g]</b>						18.0				
<b>B-03 [g]</b>							18.0			
<b>B-04 [g]</b>								18.0		
<b>B-05 [g]</b>									18.0	
<b>B-06 [g]</b>										18.0
<b>C [g]</b>		21.0	21.0	21.0	21.0	21.0	21.0	21.0	21.0	21.0
Addition of blocked pre-polymer ( <b>C1</b> ) [g]				14.7						
Dicyandiamide ( <b>D</b> ) [g]		3.4	3.9	3.4	4.0	4.0	4.0	3.9	4.0	4.0
Filler mixture ( <b>E</b> ) [g]		22.0	22.0	22.0	22.0	22.0	22.0	22.0	22.0	22.0
Hexanediol diglycidyl ether ( <b>F</b> ) [g]			1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5
ED-506 ( <b>F</b> ) [g]		2.4	2.4	2.4	2.4	2.4	2.4	2.4	2.4	2.4
TSS [MPa]	19.9	21.2	20.5	15.8	19.8	18.8	19.2	19.6	19.1	20.7
FE <sup>1</sup> at 50°C [J]	18.0	14.0	12.3	8.8	14.3	12.9	13.6	14.9	13.6	14.5
FE <sup>1</sup> at 23°C [J]	17.8	11.2	9.6	7.4	14.4	13.0	13.2	13.2	14.0	14.7
FE <sup>1</sup> at 0°C [J]	16.2	5.8	6.3	6.4	14.0	12.4	12.9	12.0	12.9	13.5
FE <sup>1</sup> at -20°C [J]	4.2	2.4	2.1	2.1	11.9	10.5	9.4	7.4	9.8	9.2
FE <sup>1</sup> at -40°C [J]	0.5	0.4	0.2	0.4	6.0	2.6	4.1	1.6	4.0	3.5

**Table 3.** Compositions and results.<sup>1</sup>FE = Fracture energy

**Results**

5 The results of the adhesive formulations in table 3 show that the combination of high strength and high impact resistance can be achieved with the compositions according to the invention, both at room temperature and at low temperatures down to -40°C.

10 Reference example **Ref-01** exhibits good impact resistances at temperatures above 0°C but has substantially lower values in comparison with the adhesives according to the invention at low temperatures, i.e. below 0°C.

15 Reference example **Ref-02** differs from the examples according to the invention substantially through the absence of the impact modifier of the formula (I) which is terminated with epoxide groups. The results show that the composition has impact resistances comparable to the compositions according to the invention at 50°C but is considerably poorer than these at lower temperatures, in particular 0°C and lower.

25 Reference example **Ref-03** comprises an added commercially available polybutadiene/acrylonitrile copolymer terminated with epoxide groups. However, the results show that the impact resistances below 50°C are substantially poorer than those of the compositions according to the invention.

30 Reference example **Ref-04** differs from **Ref-02** substantially in that it contains twice as much blocked polyurethane prepolymer of the thixotropic agent. However, the results show that, in spite of its 35 flexibilizing character, this is by no means required for the impact resistances.

The compositions **z-01** to **z-06** according to the

- 31 -

invention all have good fracture energies. These values are particularly advantageous at temperatures of from 0°C to -40°C.